

Work Order ID 63545 -1

Thursday, November 04, 2010 10:01:08 AM



Page 1

Item ID: D3537-1

Accept



Setup Start



Revision ID:

Item Name: Wearpad

Stop



Start Date: 11/4/2010 Start Qty: 60.00



Cust Item ID:

Required Date: 11/19/2010 Req'd Qty: 60.00



Customer:

Reference:

Approvals:

Process Plan:

Handwritten signature

Date: 10-11-04

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3537

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3537 Dwg Rev: C Prog Rev: C 2-Deburr if necessary

304.063

10-11-4

72

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

10-11-4

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8.06105

count
x72

Dart Aerospace Ltd

W/O: 63545		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-11-24	150	Took 3 plates for testing	EL	10-11-24	3	U 10-11-24	

Part No: D3537-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

0.00

0.00

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326. 2-Identify as D3537-1

JB 10/11/08

72

140



Large Fab

Large Fab

Large Fab

Memo

0.00

0.00

Qty Description Batch A/R 2059B Hardcoat
1-1-Weld as per Dwg D3537 using Jig DT 8210 2-Remove any weld that penetrated through Wearpad if necessary

EL 10-12-06

x33

150



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

Memo

0.00

0.00

10/12/06

counts
x33

W/O:		WORK ORDER CHANGES					
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Item Name: Wearpad

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Cust Item ID:

Required Date: 11/19/2010 Req'd Qty: 60.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8.10/12/06

count
433

170

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

M. 112588.

Memo

0.00

Powder Coating

START TIME:

3:45

OVEN TEMPERATURE:

300°

FINISH TIME:

4:15

33

BL 10-12-8.

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

=> M 10/12/09

33

Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Accept



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Revision ID:

Stop



Item Name: Wearpad

Start Date: 11/4/2010 Start Qty: 60.00



Cust Item ID:

Required Date: 11/19/2010 Req'd Qty: 60.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 Packaging	Identify as per dwg & Stock Location: <i>FR-17</i>	0.00				<i>33</i>	<i>10-12-9.</i>		
Packaging	Memo	0.00							
200 QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

10/12/09

Bl 10-12-9
(33)

W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Thursday, November 04, 2010 10:01:12 AM

Page 1

Work Order ID: 63545



Parent Item: D3537-1



Parent Item Name: Wearpad



Start Date: 11/4/2010

Required Date: 11/19/2010

Start Qty: 60.00

Required Qty: 60.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA 		Purchased	No			100	sf	178.9000	0.106	6.694737	7-7		
304/316 Sheet .063											1810-11-4		

Location

Loc Qty

Loc Code

MAT

178.9

111323

0

115688

18.9

115953

160

115688

12

W/O:		WORK ORDER CHANGES					
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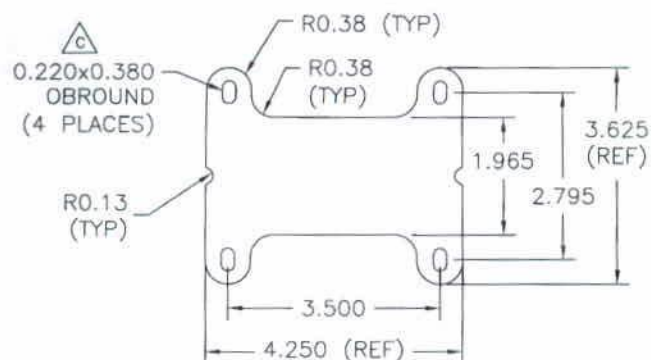
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

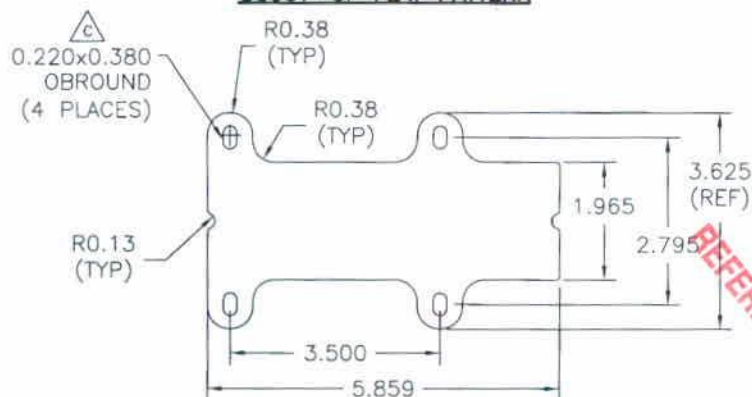
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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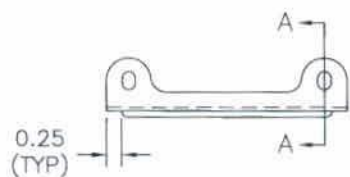
D3537-1F FLAT PATTERN



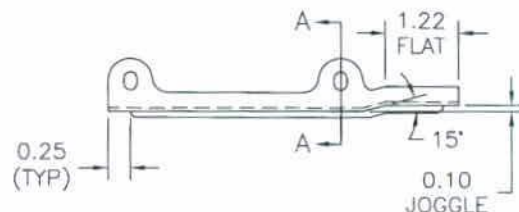
D3537-3F FLAT PATTERN



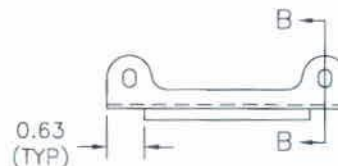
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



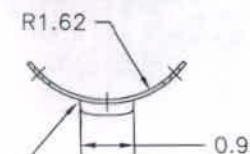
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)

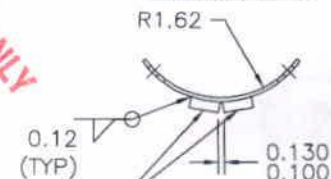


SECTION A-A



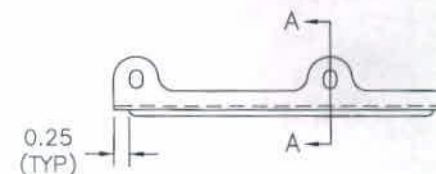
APPLY 2 LAYERS OF
2059B HARDCOAT WELDS
TO WITHIN 0.25 OF
WEARPAD ENDS
0.188 TO 0.250 THICK

SECTION B-B



D2941-300
REMOVE POWDER
COAT FROM THESE
SURFACES

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	C.B.	DRAWN BY
CHECKED	4	APPROVED
DATE	07.04.13	TITLE
		WEARPAD
		DART AEROSPACE USA, INC. PORT HADLOCK, MA
		DRAWING NO. D3537
		REV. C SHEET 1 OF 1 SCALE 1:2

RELEASED
07-05-08 AM
PCE/ECW
962